

Work Order ID 69900 - 1 Splk

Tuesday, May 24, 2011 12:34:34 PM



Page 1

Item ID: D3943-041

Accept

Revision ID:



Setup Start



Item Name: Ground Handling Crank Assembly

Stop



Start Date: 5/24/2011

Start Qty: 5.00

Required Date: 5/31/2011

Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: JMF

Date: 11-05-24 Tooling:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3943

C

100

0.00



Purchasing

Purchasing

Memo

Issue P/O:

14152

Purchase Part Number: 8143919

Supplier: Princess Auto

Certificate of conformity is required

Description: 4000 lbs lever chain hoist

0.00

(STIG)

CL 1105124 (8) 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Packaging

Memo

Ensure material certification is attached

0.00

11/15/31 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 5/31/2011 Req'd Qty: 5.00



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

8 hrs / 31

(40)

130



Large Fab

Large Fab

Memo

1-Disassemble chain host as per dwg

2-Drill handle ass'y (D3943-051) as per dwg

0.00

0.00

11-9-76

(45)

W/O:		WORK ORDER CHANGES					
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Required Date: 5/31/2011 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/11/2011

160



Powdercoat

Powder Coating

Hybrid safety Yellow 4.3.5.12

0.00

Memo

0.00

1- POWDER COAT

Start Time: _____

Oven Temperature: _____

Finish Time: _____

N/A

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EL 11-9-26 X5

190

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble as per dwg
(assy landyard CBL-1240 to CBL-460)
2- touch up with paint if necessary

EL 4/09/14 10
EL 11-9-26 X5

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1-Calibrate and tag as per dwg and QSI 008 4.4
Calibration Cert. filled out

8 ulos/26
EL 11-9-26

X5

CALIBRATION

ID: D3943-041
BY: S DATE 4/09/26
DUE: Pre-set to 3500 - 3800 lbs

X5

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 2 SUR

72990

0.00

Packaging

10/17/26 (5)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27 JF
ME 11-09-27

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Picklist Print

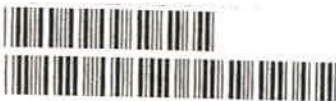
Tuesday, May 24, 2011 12:34:31 PM

Page 1

Work Order ID: 69900

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly



Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A New Issue 09-06-02 EC Verified By: JLM
add DEO DD 09.11.18 verified by:JLM
REV.C DD 10.02.22 verified by:EC
IPP RevB:
IPP Rev:C as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

8143919



Lever Chain Hoist

Purchased

No

110

Each

4.0000

1

810

11/03/10

Location

ST

Loc Qty

4

4

68810

D3943-051



Handle Assembly

Manufactured

No

180

Each

0.0000

1

810

11-9-26

70853 X5

D3943-053



Chain Assembly

Manufactured

No

180

Each

0.0000

1

810

11-9-26

70851 X5

D3943-3



Handle Extension

Manufactured

No

180

Each

3.0000

1

810

11-9-26

70028 X5

Location

ST139d

Loc Qty

3

3

63739

CBL-1240



Cable

Purchased

No

180

1

387.5000

1

810

11/09/14

Location

ST284

Loc Qty

387.5

87.5

300

113565

116438

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 69900

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

CBL-460

Purchased No

180 Each

86.0000

2



Loop Sleeve

Location

Loc Qty

Loc Code

ST284

86

116953

86

180

Each

89.0000

1

D3585-1

Manufactured No



Set Screw

Location

Loc Qty

Loc Code

GA

89

55705

89

180

Each

25.0000

1

D3949-041

Manufactured No



Remove before Flight Flag Assembly

Location

Loc Qty

Loc Code

ST487

25

48280

25

180

Each

2.0000

1

D3954-7

Manufactured No



Ratchet Lug

Location

Loc Qty

Loc Code

ST097

2

63738

2

180

Each

92.0000

1

ANS-11A

Purchased No



Bolt

Location

Loc Qty

Loc Code

ST337

92

117313

92

11/8/11

5

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Shop Packet Print

Page 2

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Page 3

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Parent Item Name: Ground Handling Crank Assembly

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

AN960-516

NAS1149F0563P

Purchased

No

180

Each

70.0000

1

810



WASHER



EL

11-9-15

Location

Loc Qty

Loc Code

ST346

70

110098

70

180

Each

1,243.000

1

810

EL

11-9-15

MS21042L5

Purchased

No



Nut



Location

Loc Qty

Loc Code

ST300

1243

116105

283

116548

260

117441

500

117591

100

117611

100

SI475

Purchased

No



inventory

180

Each

9.0000

1

810

EL

11-9-15

Location

Loc Qty

Loc Code

ST396

9

113847

9

180

Each

17.0000

1

810

EL

11-9-15

3408A59

Purchased

No



BALL PLUNGER



Location

Loc Qty

Loc Code

ST401

17

111948

2

113854

15

5

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Shop Packet Print

Page 3

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Page 4

Work Order ID: 69900

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Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 5.00

Required Qty: 5.00

HX-15



1/4-20 UNCx3/4 S.H.C.S.

Purchased

No

180

Each

45.0000

1

810



EZ

11-9-15

Location

Loc Qty

Loc Code

MEZZ

45

114383

45

180

Each

85.0000

3

5

15-30

EZ

11-9-15

HX-16



Purchased

No

Location

Loc Qty

Loc Code

ST390

85

117346

85

M113771

75

Tuesday, May 24, 2011 12:34:32 PM

Shop Packet Print

Page 4

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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	
12	1			D3943-3	HANDLE EXTENSION	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	
16			1	D4405-1	EYE AND FORK SWIVEL	USE CHAIN SUPPLIED WITH ITEM 39
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 0.75 LG	HASKINS
54	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

RELEASED
2011-05-24

D	SHT 1 PL, ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED). SHT 2 ZN D3 FLAG RELOCATED, SHT 3 ZONE D3, Ø9.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1), PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV	DESCRIPTION	BY	DATE
DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO. D3943	REV. D SHEET 1 OF 5
CHECKED		TITLE GROSS WEIGHT TOW CRANK ASSY.	SCALE NTS
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	11.05.16	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D3943-1 HANDLE

2 PL

9.75

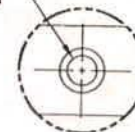
2.00

Ø0.31
THRU

D3943-7 STUD
2 PL

THREAD $\frac{1}{4}$ -20 UNC-2B
2 PL

THREAD $\frac{1}{4}$ -20 UNC-2B
THRU



VIEW A-A
A5-3
(SCALE 2X) B5-3

2 PL

9.38

A B1-3



D3943-5 PLATE

A B1-3

D3943-051 HANDLE ASSEMBLY

NOTES -051:

- 1) MATERIAL : N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS
PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO FINISHING

DESIGN	DSTQW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3943	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.05.16	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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RELEASED
2011-05-24

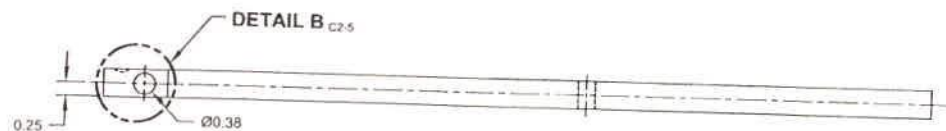
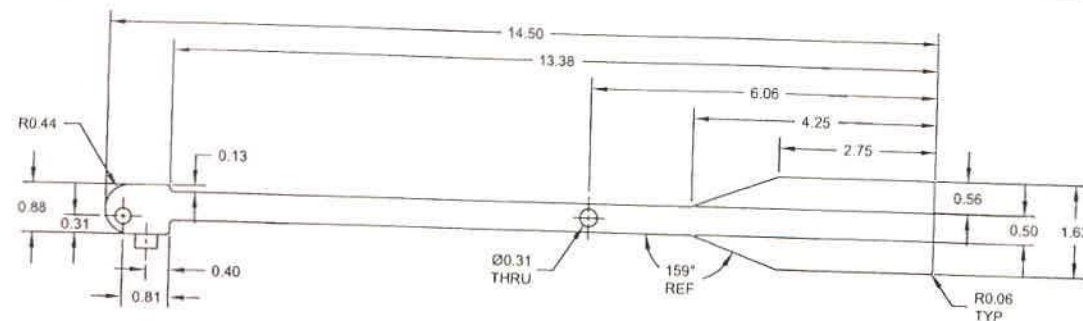
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

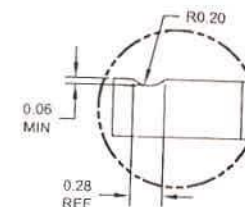
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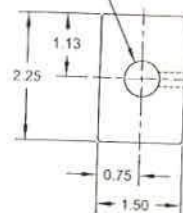


D3943-3 HANDLE EXTENSION

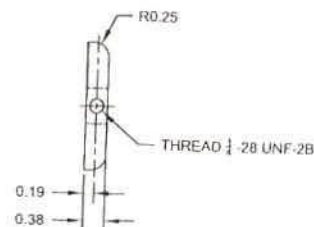


DETAIL B-B C7-5
(SIMPLE DETAIL)
(SCALE 2X)

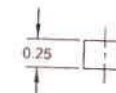
THREAD $\frac{1}{8}$ -11 UNC-2B



D3943-5 PLATE



Ø0.38 PILOT HOLE PER SHOP REQUIREMENT



D3943-7 STUD
(SCALE 2X)


NOTES -11/-13:

1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3943	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.05.16	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER OR IN ANY MANNER DATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

RELEASED
2011-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PO Box 1005 Winnipeg, MB R3C 2W7

Phone (204) 667-4630 Fax (204) 663-7663 www.princessauto.com

A/R CHARGE

613 632 1053

DATE	INVOICE NUMBER	ACCOUNT NUMBER	STORE NUMBER
30/05/2011 DD/MM/YY	1663072	073126	16

BILL TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

SHIP TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

QUANTITY	DESCRIPTION	UNIT PRICE	AMOUNT
50 1	B 8143919 - HOIST CHAIN 2 TON LEVER	\$159.99	\$799.95
	G 9999998 - HANDLING FEE	\$6.00	\$6.00
<p style="text-align: center;">Sulor 131</p> <p style="text-align: center;">CTS: Ø</p> <p style="text-align: center;">TR: FEDEX</p>			
SUBTOTAL			\$805.95
PST			\$0.00
GST / HST			\$104.29
TOTAL			\$910.24

PRINT NAME

SIGNATURE

TERMS: NET 30 DAYS.
2% PER MONTH (24% PER ANNUM COMPOUNDED MONTHLY) INTEREST ON OVERDUE ACCOUNTS.

P.O. NUMBER
14152

Please Pay
A/R Account

\$910.24

PRINCESS AUTO RESPECTS YOUR PRIVACY.
FOR MORE INFORMATION VISIT www.princessauto.com/privacy
OR ASK A TEAM MEMBER.

G.S.T. REG. #R104304736

Our Royal Service Promise

NO SALE IS FINAL UNTIL YOU'RE SATISFIED!

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PRINCESS AUTO

PO Box 1005 Winnipeg, MB R3C 2W7

Phone (204) 667-4630 Fax (204) 661-0458 www.princessauto.com

A/R CHARGE

DATE	INVOICE NUMBER	ACCOUNT NUMBER	STORE NUMBER
28/05/2011 DD / MM / YY	1461917	073126	18

BILL TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

SHIP TO:

DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

QUANTITY	DESCRIPTION	UNIT PRICE	AMOUNT
5 1	B 8143919 - HOIST CHAIN 2 TON LEVER G 9999998 - HANDLING FEE S 11/10/31	\$159.99 \$6.00	\$799.95 \$6.00
		SUBTOTAL	\$805.95
		PST	\$0.00
		GST / HST	\$104.29
		TOTAL	\$910.24
PRINT NAME _____ SIGNATURE _____		Please Pay A/R Account	
TERMS: NET 30 DAYS. 2% PER MONTH (24% PER ANNUM COMPOUNDED MONTHLY) INTEREST ON OVERDUE ACCOUNTS.		\$910.24	
P.O. NUMBER PO14152			
PRINCESS AUTO RESPECTS YOUR PRIVACY. FOR MORE INFORMATION VISIT www.princessauto.com/privacy OR ASK A TEAM MEMBER.			

G.S.T. REG. #R104304730

G.S.T. REG. #R104304738

Our Royal Service Promise

NO SALE IS FINAL UNTIL YOU'RE SATISFIED!

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

INTERNAL CALIBRATION CERTIFICATE

Instrument #	Description	Serial #
D3943-041	Ground Handling Crank Assembly	B69900

Calibrated by	Date of calibration	Calibrated with	Due	Certificate #
ED	Sept 26th, 2011	ENG-07		
		25000lbs load cell		

New tool	Disposed	In Repair	On Hold	Being Calibrated
N/A	N/A	N/A	N/A	N/A

Employee	Department	Comments:
N/A	N/A	MUST BE CALIBRATED WITH IN 1 YEAR OF PURCHASE OR FIRST OPERATION

Spec.	Tolerance is + /-	Result	Pass Fail
3500LBS	3500-3700LBS	3640 lbs	PASS

Entered By:
Eric Downing QC Coordinator

REFERENCE ONLY

8/26/12